

Work Order ID 159862

Wednesday, April 19, 2017 11:29:59 AM

Page 1

646.3911
B159862
REV. N/C1

159862

Item ID: 646.3911

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shim

Start Date: 4/20/2017 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/11/2017 Req'd Qty: 20.00

20

Customer:

Reference: SCHEDULED/S

Approvals: Process Plan:

21

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

646.3900

nc1

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

0.48

1-Cut as per Dwg

Dwg Rev: NC1

Prog Rev: NC1

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.20

(21)

04/17/05/31

(21)

04/17/05/31

Picklist Print

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Work Order ID: 159862

159862

Parent Item: 646.3911

646 3911

Parent Item Name: Shim

Start Date: 4/20/2017

Required Date: 5/11/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.032		Purchased	No			110	sf	2.4000	0.03	0.631578			

MC1095S 032

C1095 Blue Tempered Spring Steel Sheet .032 mcmaster p/n: 9036K507

04/17/25/31

Location

Loc Qty

Loc Code

MAT019

2.4

M130477

2.4

9

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05243

SHEET 1 OF 1

DWG NO. 646.3900

REV: N/C PREPARED BY J. BECKER

DATE: 11/13/15

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: SHIM

APPROVED BY:

ENGR. *[Signature]*

MFG *[Signature]*

QC *[Signature]*

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):

A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED VIEWS. UPDATED TEMPLATE AND TITLE BLOCK.

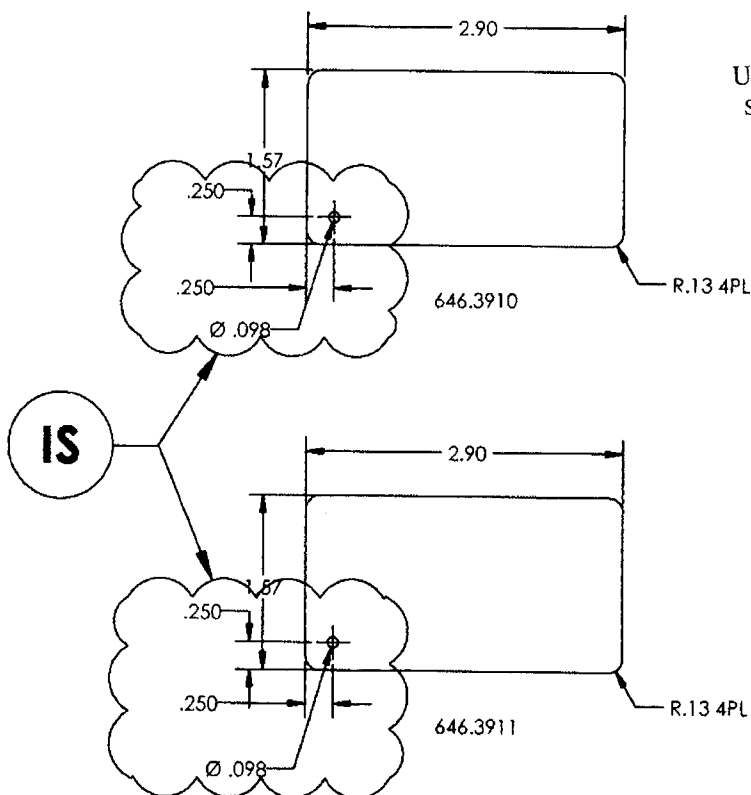
ECR:

15-275

ACTION ITEM:

1. N/A.

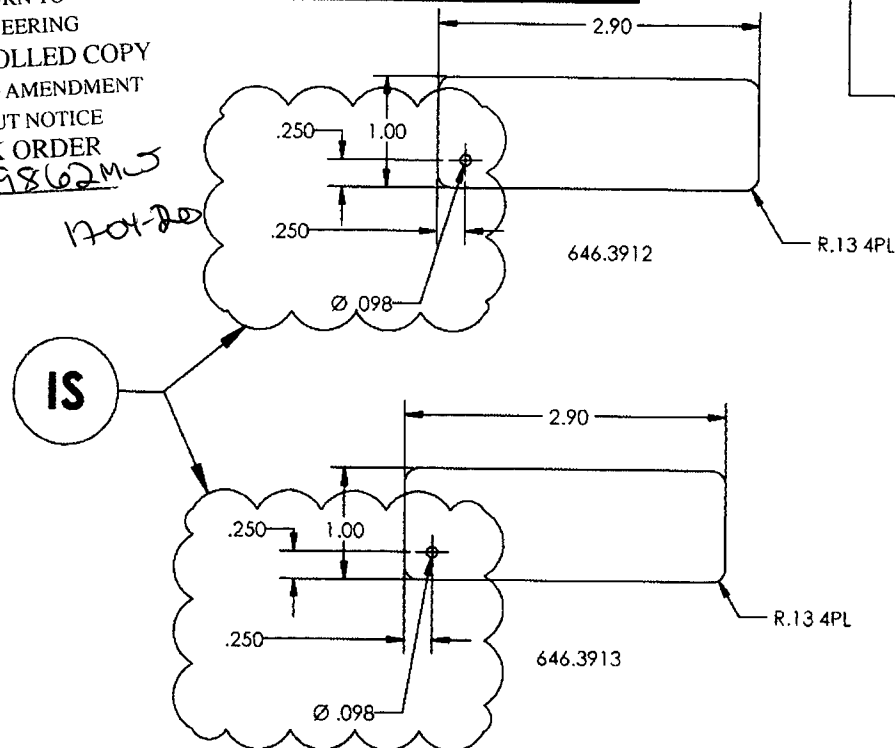
SHEET 1, ZONE B2 IS:



SHEET 1, ZONE C2 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159862M-5
1704-20

SHEET 1, ZONE B5 IS:



SHEET 1, ZONE C5 IS:

DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

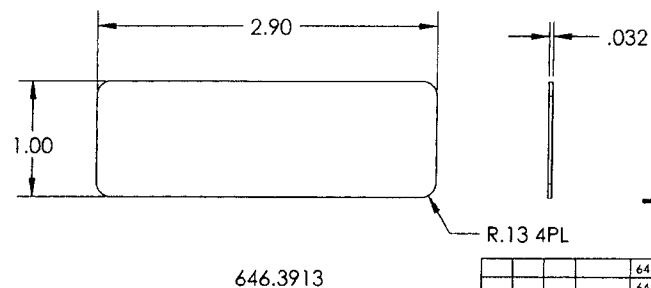
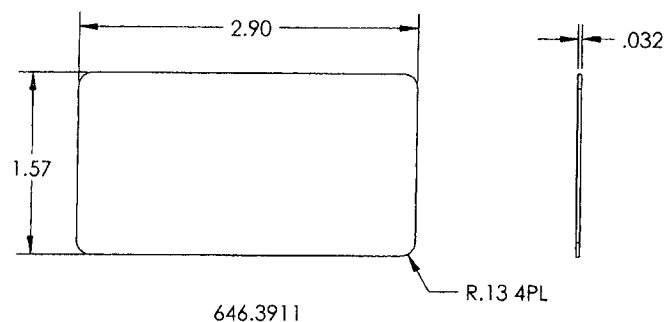
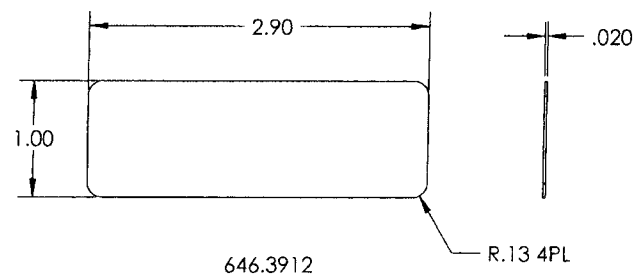
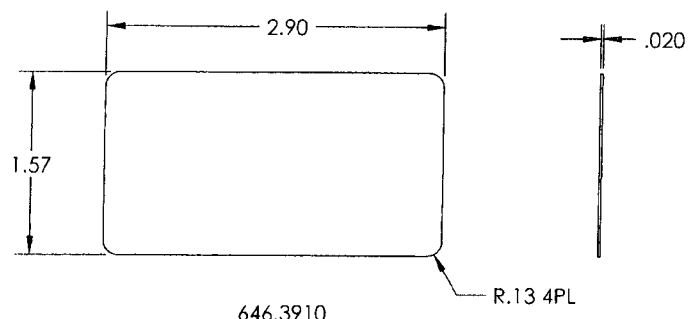
☐ YES ☒ NO

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

NOTES:

- 1 MATERIAL: SHIM STOCK, C1095 BLUE-TEMPERED SPRING STEEL
- 2 FINISH: CAD PLATE PER QQ-P-416 TYP II CL2
- 3 IDENTIFY IAW MPP-120



UNINCORPORATED ECN(s)

05243

		646.3913	SHIM	△	△
		646.3912	SHIM	△	△
		646.3911	SHIM	△	△
		646.3910	SHIM	△	△
	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY			PARTS LIST		
NEXT ASSY (S)			APICAL INDUSTRIES		
646.4000	ORIGINAL DATE: 06-03-08 DRAWN BY: J. HUFF CHECKED BY: J. BRAVO DRAWING APPROVAL:  DATE: 06-03-08 CONTRACT NO.:		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS F005 ANGLES ± .5			SHIM		
SCALE: NONE			DET: 0 SCALE: NONE	CASE CODE: 07MZE 646.3900	REV: N/C 1 OF 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36552**

Purchase Order Date 6/2/2017

PO Print Date 6/2/2017

Page Number 1 of 2

Order From :

GROUP ALTECH
2455 HALPERN

ST LAURENT, MONTREAL H4S 1N9

VC-ALT01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUN 05 2017

Contact Name

Vendor Phone 514-335-3666

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FOB Origin

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	159854	646.3910 SHIM	6/14/2017 Yes 6/14/2017		52.00	\$3.55	\$184.82
CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2							
Line Total:							\$184.82
2	159862	646.3911 SHIM	6/14/2017 Yes 6/14/2017		21.00	\$3.55	\$74.64
CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2							
Line Total:							\$74.64
3	161802	646.3912 SHIM	6/14/2017 Yes 6/14/2017		10.00	\$3.55	\$35.54
CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2							

Note:

6/2/2017



2455, Halpern, Saint-Laurent, QUÉBEC, H4S 1N9
Tel.: (514) 335-3666 Fax.: (514) 335-3868
Internet : www.groupealtech.com

**Bon de livraison / Packing Slip
et / and
Certificat de conformité / Certificate of Compliance**

Bon-Livraison / Pk.Slip # : 127933-1 09/06/2017
Bon-Commande. / W.Order # : 127933
Client P.O. # : 622017
Transport :

Envoyé à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

Commandé par / Order by

DART AEROSPACE LTD (1427)
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

#	No. Job No. Réf	NoSerie / Part Number Nom Produit / Product	Traitement Process	Poids Weight	Qté Qty	Envoyé Sent	A venir BO
1	UNIT	159854 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:3	0.00	52	52	0
2	UNIT	159862 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:3	0.00	21	21	0
3	UNIT	161802 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:3	0.00	10	10	0

SP176-13

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

[Signature]

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.